

SHIP TUESDAY 23/07



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

654.0810-NC
Job Sheet 197705



Part No: 654.0810-NC

Job Qty: 2 pcs

Part Name: Adjustment Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/15/19

Job Tracking No:

Due Date: 7/17/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG 654.0800 REV.N/C IPP REV:A 19.07.15 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	2 pcs		7/17/19	0.17	0.33	Waterjet - Flow		JRB 7/15/19
120	QC 2	2 pcs		7/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 7/15/19
130 QC 8	2 pcs	7/17/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JUL 16 2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Conventional Mill - 1 - B4B	2 pcs	7/17/19	0.25 0.20	Conventional Mill - 1 - B4B	W 19/7/19
				Conventional Mill - 2 - B4B	
150 QC 5	2 pcs	7/17/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JUL 22 2019 40 9-89
				QC 5 - 61	
				QC 5 - 81	
160 Handfinish - 1-1 Chemical-B4B	2 pcs	7/17/19	0.00 0.10	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SA JUL 23 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	

1138834. START: 8:10
O.T. 30°
Finish: 8:40
mask holes

163 - Powdercoat gloss black

165 - QC 3

DAS
81
9-89

JUL 23 2019

BL 19-7-23.

Handfinish - 1 - 7 - B4B
Handfinish - 1 - 8 - B4B
Handfinish - 1 - 9 - B4B
Handfinish - 1 - 10 - B4B
Handfinish - 1 - 11 - B4B
Handfinish - 1 - 12 - B4B
Handfinish - 1 - 13 - B4B
Handfinish - 1 - 14 - B4B
Handfinish - 1 - 15 - B4B
Handfinish - 1 - 16 - B4B
Handfinish - 1 - 17 - B4B
Handfinish - 1 - 18 - B4B
Handfinish - 1 - 19 - B4B
Handfinish - 1 - 20 - B4B
Handfinish - 1 - 21 - B4B
Handfinish - 1 - 22 - B4B

170 QC 7

2
pcs

7/17/19

0.00 0.00

QC 7 - 10
QC 7 - 13
QC 7 - 14
QC 7 - 15
QC 7 - 17
QC 7 - 18
QC 7 - 19
QC 7 - 2
QC 7 - 28
QC 7 - 3
QC 7 - 30
QC 7 - 34
QC 7 - 36
QC 7 - 37
QC 7 - 41
QC 7 - 47
QC 7 - 48
QC 7 - 51
QC 7 - 58
QC 7 - 59
QC 7 - 60
QC 7 - 9
QC 7 - 68
QC 7 - 50
QC 7 - 67
QC 7 - 40
QC 7 - 24
QC 7 - 43
QC 7 - 61
QC 7 - 81

DAS
81
9-89

JUL 23 2019

180 Packaging 3-1 - Stock - B4B

2
pcs

7/17/19

0.00 0.00

Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B

105 7-23-2019



0.2

Bin: ST:CK126

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	2 pcs	7/17/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - 1-Cut as per DWG. DWG. Rev: <u>N/C</u> PROG. Rev: <u>N/C</u> 2-Deburr if necessary Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - C'SINK HOLES AS PER DWG AND DEBURR 150 - QC5- Inspect part completeness to step on W/O 160 - Chemical Conversion Coat per QSI005 4.1 170 - QC7-Inspect Chemical Conversion Coat 180 - Identify as per dwg & Stock Location: _____ 190 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S6.000X0.250 <u>M606T6S.250</u>	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	8160 ft (.408 ea) <u>.140 SF (Each)</u>	110-Waterjet - Flow - 1	<u>5159676</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Flow - 1	M7075T6S6.000X0.250 <u>M606T6S.250</u>	1	2	0	
Part Specifications					
Specifications could not be found.					

DAS
21 JUL 23 2019
9-83

19.07.15

David Duval

From: Pablo Bravo
Sent: Monday, July 15, 2019 11:43 AM
To: Jean-Luc Menard
Cc: David Duval; Linda Lacelle; David Mejia
Subject: Re: 654.0800 plate

JL,

Approved. Please proceed with 6061.

PABLO BRAVO

Director of Engineering – San Diego

DART AEROSPACE

T 1 760 724-5300 > 106

O 1 760 509-1606

F 1 760 509-1562

1 800 556- 4166

www.dartaerospace.com

On Jul 15, 2019, at 8:41 AM, Jean-Luc Menard <jmenard@dartaero.com> wrote:

Hi Pablo,

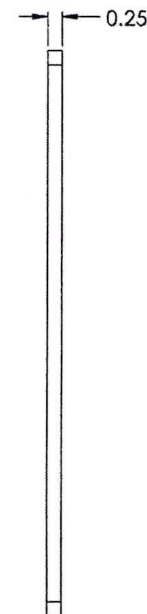
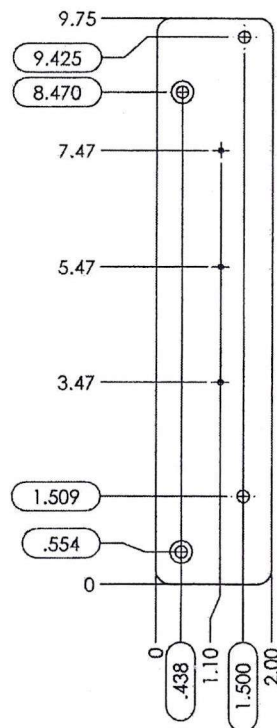
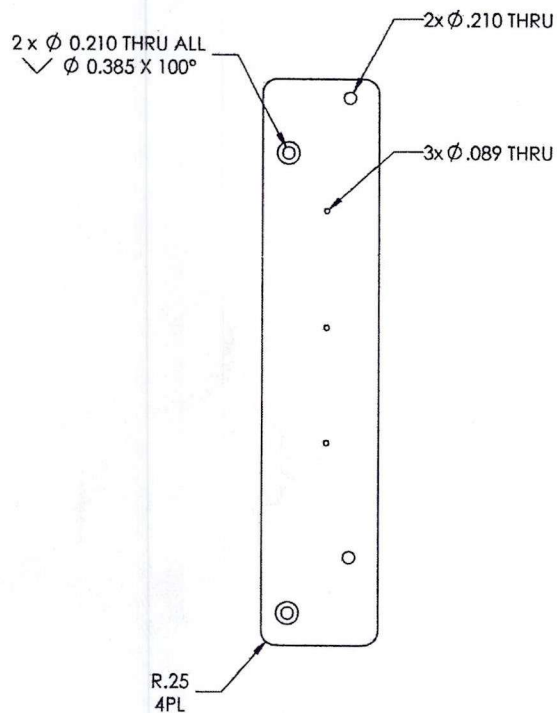
As discussed, can you approve using 6061-T6 instead of 7075 for the plate.

Thx

JL

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- 1 MATERIAL: 7075-T6/T62/T651 PER QQ-A-250/12 OR QQ-A 200/11
 2 ALODINE FINISH "CHEMICAL CONVERSION COAT PER DART QSI 005 4.1"



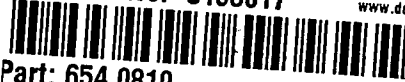
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	07-11-19	P. BRAVO

1	654.0810	ADJUSTMENT PLATE	1	2
F/N/PART #	DESCRIPTION	MAT'L	SPEC.	
QTY	PARTS LIST			
NEXT ASSY (S)	ORIGINAL DATE	07-11-19	DART 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300 APICAL INDUSTRIES INC. DBA DART AEROSPACE	
NONE	DRAWING APPROVAL	07-11-19		
	CORRECTION NO.			
	UNLESS OTHERWISE SPECIFIED			
	DIMENSIONS ARE IN INCHES		ADJUSTMENT PLATE	
	TOLERANCES ARE:		SCALE NONE	
	1 PLACE DECIMALS ±.01		SHEET 1 OF 1	
	2 PLACE DECIMALS ±.005			
	3 PLACE DECIMALS ±.0005			
	ANGLES ±.5°			



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1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Container No: S198017



Part: 654.0810

Job No: 197705

Serial No/Batch: S198017

Revision: N/C

Inspector:

Exp Date:

Instructions:

Date: 07/15/19

INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

David Duval

From: David Mejia
Sent: Monday, July 15, 2019 5:40 PM
To: David Duval; Pablo Bravo
Subject: RE: 654.0800 plate

David,

The .094 is acceptable. They are pilot holes and will be drilled out to 0.125" during installation.

Best regards,
David Mejia

From: David Duval
Sent: Monday, July 15, 2019 12:14 PM
To: Pablo Bravo <pbravo@dartaero.com>
Cc: David Mejia <dmejia@dartaero.com>
Subject: RE: 654.0800 plate

Hi Pablo.

We just cut 654.0810 on the waterjet and the 0.089" is actually at 0.094". Is this acceptable or we should cut some more.

Thanks.
David Duval
Production Engineering Supervisor

From: Pablo Bravo
Sent: Monday, July 15, 2019 11:43 AM
To: Jean-Luc Menard <jmenard@dartaero.com>
Cc: David Duval <dduval@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; David Mejia <dmejia@dartaero.com>
Subject: Re: 654.0800 plate

JL,

Approved. Please proceed with 6061.

PABLO BRAVO
Director of Engineering – San Diego

DART AEROSPACE
T 1 760 724-5300 > 106
O 1 760 509-1606
F 1 760 509-1562
1 800 556- 4166
www.dartaerospace.com

Linda Lacelle

From: David Shepherd
Sent: Monday, July 22, 2019 1:54 AM
To: Jean-Luc Menard
Cc: Sian Willems; Linda Lacelle; David Mejia; Pablo Bravo; Marc Bellavance
Subject: FW: EC130 Heli-Lynx supporting EFS installation

197705
conv.

SalesforceTaskId: 00T5A00004c6xkD
SfdcUserId: 005i00000000gbStAAI

JL,

Can you make sure that the 654.0810 Adjustment Plates that you made last week are painted black to match the 652.4701 Reservoir Brackets that they will be attached to.

Thanks,
David

From: Sian Willems <swillems@dartaero.com>
Sent: July 11, 2019 1:24 PM
To: Marc Bellavance <mbellavance@dartaero.com>
Cc: David Mejia <dmejia@dartaero.com>; Marcelo Gonzalez <mgonzalez@dartaero.com>; Pablo Bravo <pbravo@dartaero.com>; Alain Madore <amadore@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Mike DiDomenico <mdidomenico@dartaero.com>; Support <support@dartaero.com>; Gordon Law <glaw@dartaero.com>
Subject: RE: EC130 Heli-Lynx supporting EFS installation

Added #6. Other changes highlighted in yellow. Added Gordon as this step involves purging/reworking current stock.

Additional notes from telecons yesterday & today:

- 1) Drawing of doubler to modify the reservoir brackets TODAY (July 11)
 - o 652.4701 brackets shipping from Vista from stock – delivery expected July 15
 - o SW spoke with JL, no issues with producing the bracket & assembling
 - o Need to ship by July 19
- 2) Drawing of new pin TODAY (July 11) 0 604.0023
 - o 604.0023-2 Pins shipping from Vista from stock – delivery expected July 15

- SW spoke with JL, no issues with modifying pins
- Need to ship by July 19
- 3) DSI to allow bracket modification and pin substitution TOMMOROW (July 12)
- 4) Hoses
 - 602.1621 qty. 2 custom length
 - 602.1620 qty. 1 custom length
 - 602.4512 float hose qty. 2 manufactured so that 10" protrude
 - 602.1622 liferaft hose qty. 2 manufactured so that 10" protrude
 - Need to ship 602.1620/21 by July 19
 - 602.4512/1622 to be used to rework returned floats
- 5) 652.2703/4 floats returning to Dart Vista
 - SW will issue RMA & communicate to customer
 - Will ship July 11 or 12 overnight service
 - Replace hoses & repack
 - Ship back to customer by July 19
- 6) 604.0021-100
 - Need to supply rev L
 - All stock is currently at rev K. Needs to be purged or reworked
 - Need to ship qty. 1 by July 19

SIAN WILLEMS

Director of Customer Support

DART AEROSPACE

T 1 613 632-3336 > 239

M 1 613 676-0577

From: Marc Bellavance <mbellavance@dartaero.com>

Sent: Thursday, July 11, 2019 3:18 PM

To: Sian Willems <swillems@dartaero.com>

Cc: David Mejia <dmejia@dartaero.com>; Marcelo Gonzalez <mgonzalez@dartaero.com>; Pablo Bravo <pbravo@dartaero.com>; Alain Madore <amadore@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Mike DiDomenico <mdidomenico@dartaero.com>; Support <support@dartaero.com>

Subject: RE: EC130 Heli-Lynx supporting EFS installation

Thanks for this update Sian.

Adding Mike DiDomenico.

For the correct hose lengths, please refer to attached "Item #2.pdf" obtained from customer. The second pages shows what the correct lengths should be as follows:

- Qty(1) 602.1620 = 28.0"
- Qty(2) 602.1621 = 51.0"
- Qty(2) 602.1622 = need to have 10" exposed from float cover (this will require some figuring out on our part)
- Qty(2) 602.4512 = need to have 10" exposed from float cover (this will require some figuring out on our part)

To this, I would like to add that we need a replacement 604.0021-100 Dual Cable Plate Assy for Heli-Lynx.

- Reason: the one they have received is at an earlier revision and requires modification Heli-Lynx prefers not to carry out.
- Discrepancy: In the forward position, the hole pattern has been replaced by a slotted pattern to accommodate the H130 airframe.
- Vista Quality must ensure that current stock is quarantined and reworked under an NCR.

Thanks,

Marc Bellavance

Mechanical Designer / Technical Support

DART AEROSPACE

T 1 613 632 5200 > 243

M 1 613 676 0992 > Customer Support

M 1 613 677 4570 > Direct

F 1 613 632 9311

S marcbellavance

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Note Customer Support has a new email address: support@dartaero.com. Please use this address for all future support inquiries. The following addresses have been retired : support.ON@dartaero.com, support.CA@dartaero.com, support.OR@dartaero.com.

For technical support, click [here](#).

To access technical documentation, create your account [here](#).

From: Sian Willems

Sent: July 11, 2019 2:30 PM

To: Marc Bellavance <mbellavance@dartaero.com>

Cc: David Mejia <dmejia@dartaero.com>; Support <support@dartaero.com>; Marcelo Gonzalez <mgonzalez@dartaero.com>; Pablo Bravo <pbravo@dartaero.com>; Alain Madore <amadore@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>

Subject: RE: EC130 Heli-Lynx supporting EFS installation

Additional notes from telecons yesterday & today:

- 1) Drawing of doubler to modify the reservoir brackets TODAY (July 11)
 - 652.4701 brackets shipping from Vista from stock – delivery expected July 15
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- 2) Drawing of new pin TODAY (July 11) 0 604.0023
 - 604.0023-2 Pins shipping from Vista from stock – delivery expected July 15
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- 4) Hoses
 - 602.1621 qty. 2 custom length
 - 602.1620 qty. 1 custom length
 - 602.4512 float hose qty. 2 manufacture to length as per dwg
 - 602.1622 liferaft hose qty. 2 manufacture to length as per dwg
 - Marc to confirm 602.1620/21 length with customer
 - Need to ship 602.1620/21 by July 19
 - 602.4512/1622 to be used to rework returned floats
- 5) 652.2703/4 floats returning to Dart Vista
 - SW will issue RMA & communicate to customer
 - Will ship July 11 or 12 overnight service
 - Replace hoses & repack
 - Ship back to customer by July 19

Thanks,
SIAN WILLEMS
Director of Customer Support

DART AEROSPACE
T 1 613 632-3336 > 239
M 1 613 676-0577

From: David Shepherd <dshepherd@dartaero.com>

Sent: Thursday, July 11, 2019 12:13 PM

To: Sian Willems <swillems@dartaero.com>; Alain Madore <amadore@dartaero.com>

Cc: David Mejia <dmejia@dartaero.com>; Support <support@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Marcelo Gonzalez <mgonzalez@dartaero.com>; Pablo Bravo <pbravo@dartaero.com>

Subject: RE: EC130 Heli-Lynx supporting EFS installation

Adding Pablo

Mejia,

Just a reminder that we need:

- 1) Drawing of doubler to modify the reservoir brackets TODAY (July 11)
- 2) Drawing of new pin TODAY (July 11)
- 3) DSI to allow bracket modification and pin substitution TOMMOROW (July 12)

I assume that Marc provided the DSI template to you yesterday.

Also, we have two other kits that shipped recently that will have the same problems.

Regards,

David

From: Sian Willems <swillems@dartaero.com>

Sent: July 10, 2019 3:56 PM

To: Alain Madore <amadore@dartaero.com>

Cc: David Mejia <dmejia@dartaero.com>; Support <support@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Marcelo Gonzalez <mgonzalez@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: EC130 Heli-Lynx supporting EFS installation

Hi Alain,

We did get feedback from the installer. Float hose is 6" too short. Liferaft hose is 30" too long. Our concerns are that liferaft hose may have been disconnected internally or possible inflation issues due to too much hose. They also confirmed both side are the same.

Here is the plan we've put together to support the EC130 float install at Heli-Lynx.

- Issue #1 liferaft reservoir brackets
 - Fabrication of doublers under the brackets to allow relocation of the brackets to correct location
 - Ship modified brackets assembled to the doublers to Heli-Lynx on July 16
- Issue #2 pins too short
 - Modify another pin part number to the correct length
 - Ship modified pins to Heli-Lynx July 16
- Issue #3 hose lengths
 - Plan A – we may have a set of floats in house in Vista which could be verified/certified and shipped to Heli-Lynx for July 16. I expect to have confirmation of the status before the end of Vista's day today

- Plan B – if in house floats cannot be recertified, return Heli-Lynx floats on July 11 for delivery in Vista July 12. Rework to correct configuration and return to Heli-Lynx. Timeline for this will need to be verified with Marcelo tomorrow

Please give me a call to discuss any of these points.

Thanks,
SIAN WILLEMS
Director of Customer Support

DART AEROSPACE
T 1 613 632-3336 > 239
M 1 613 676-0577
F 1 613 631-4443
1 800 556- 4166
www.dartaerospace.com

Note Customer Support has a new email address : support@dartaero.com. Please use this address for all future support inquiries. The following addresses have been retired : support.ON@dartaero.com, support.CA@dartaero.com, support.OR@dartaero.com.

For *technical support*, click [here](#).

If you wish to access *technical documentation* online, please create your account [here](#).

